

Work Order ID 74707

Wednesday, October 05, 2011 12:31:04 PM

Ship Rush ASAP!
Today



Item ID: D3675-1

Accept



Setup Start



Revision ID:

Stop



Item Name: SLIDING DOOR BRACKET

Start Date: 10/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3675

RevD

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

Bit-10-6

FLOW CNC Waterjet

1-Cut as per Dwg D3675

Dwg Rev: *D*

Prog Rev: *D*

2-Deburr if necessary

(16)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Bit-10-1C

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Sum 10/6/6

(16)

Quality Control

Work Order ID 74707

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Page 2

Item ID: D3675-1

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Required Date: 10/7/2011 Req'd Qty: 5.00

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3675 use DT9723

0.00

0.00

8 11/10/11

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 11/10/11

8/6

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

2-20
3200 F
2-30

16X Ø m-11/10/11

M118489

Work Order ID 74707

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Page 3

Item ID: D3675-1

Accept



Setup Start



Revision ID:

Item Name: SLIDING DOOR BRACKET

Stop



Start Date: 10/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

16
COUNT

11/10/11

170

Identify as per dwg & Stock Location: 236A

0.00



Packaging

Memo

0.00

Packaging

11/10/11

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11

YMF
11-10-11

Picklist Print

Wednesday, October 05, 2011 12:31:02 PM

Page 1

Work Order ID: 74707



Parent Item: D3675-1

Parent Item Name: SLIDING DOOR BRACKET

Start Date: 10/5/2011

Required Date: 10/7/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A new issue 08-04-21 DD verified by:EC IPP Rev:B
11.01.11 as per dwg rev.C DD verified by:EC IPP Rev C 11.03.31
ECN 11-531 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	147.0795	0.121	0.636842	2.		



304/316 .040 Sheet



B11-10-8

Location

Loc Qty

Loc Code

MAT020

147.0795

116623

0.2

117550

8.363

117933

45.3442

118400

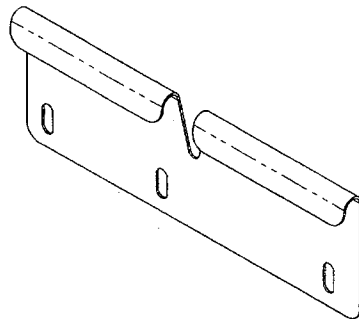
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118964

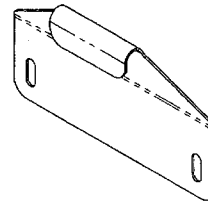
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117933

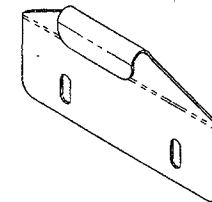
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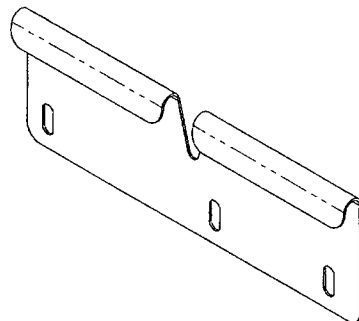
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**

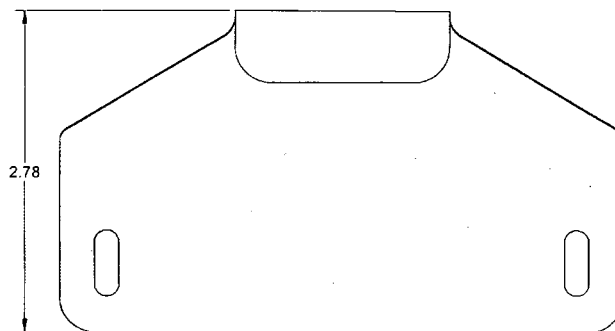


D3675-6 SLIDING DOOR BRACKET

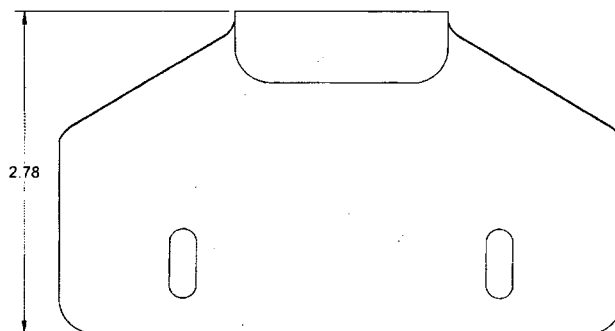
W/O 74707

RELEASED
R 2011-03-31 D

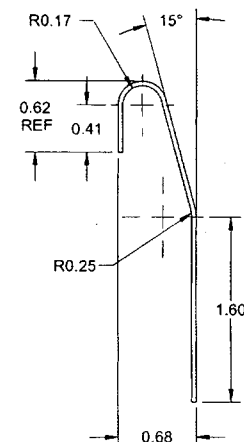
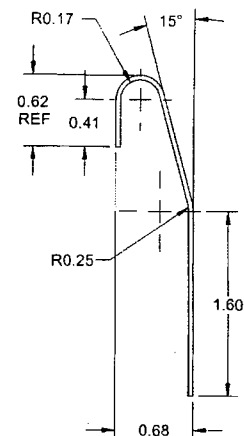
REV.	DESCRIPTION	BY	DATE
D	RE-DESIGNED D3675-5/-6/-6F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF. PAR11-79.	MB	11.03.21
C	ADD -5/-5F/-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3675 REV. D TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR) SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED	AJS		
MFG. APPR.	AJS		
APPROVED	AJS		
DE APPR.	AJS		
DATE	11.03.21		



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



RELEASED
2011-03-31
JH

NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 2 OF 6
APPROVED	AS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AS	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS
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8 7 6 5 4 3 2 1

D

D

C

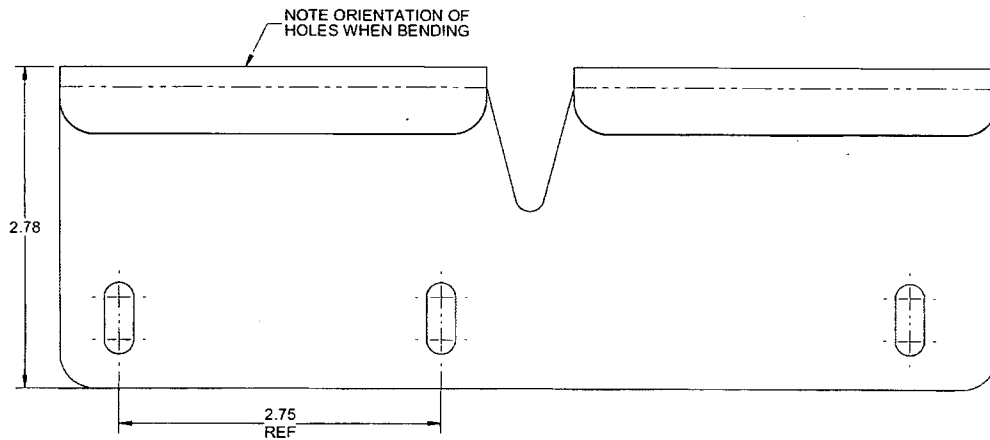
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B

B

A

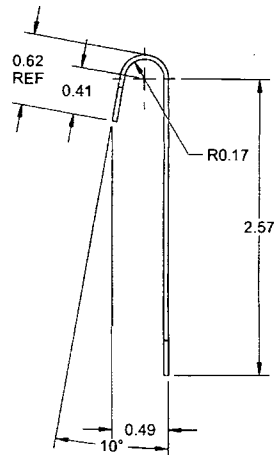
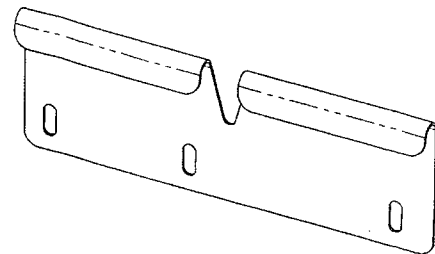
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D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.



RELEASED
R 2011-03-30
JW

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AB		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AB	D3675	SHEET 3 OF 6
APPROVED	AB	TITLE	SLIDING DOOR BRACKET (COMPOSITE DOOR)
DE APPR.	AB	SCALE	NTS
DATE	11.03.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

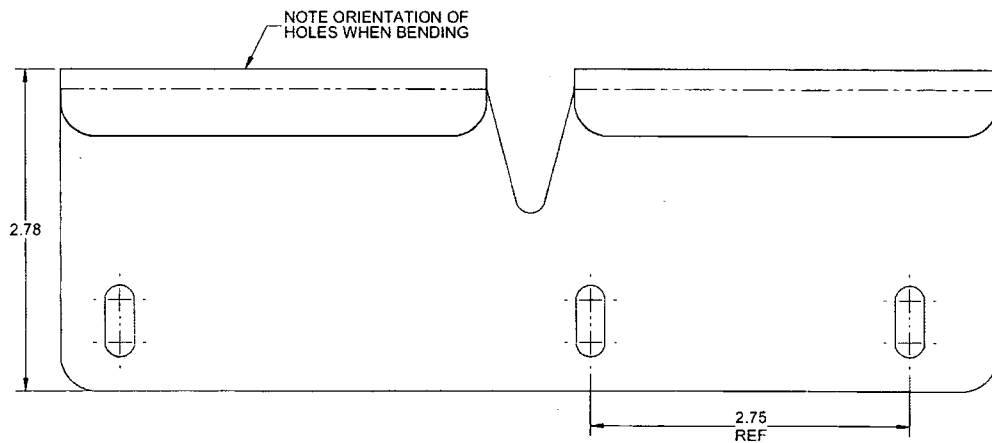
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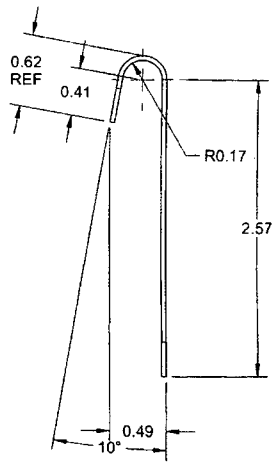
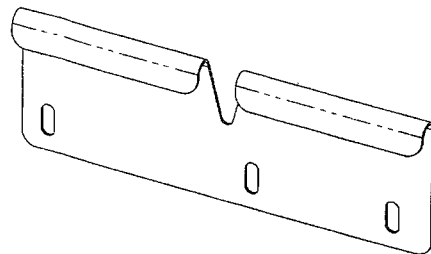
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B

A



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



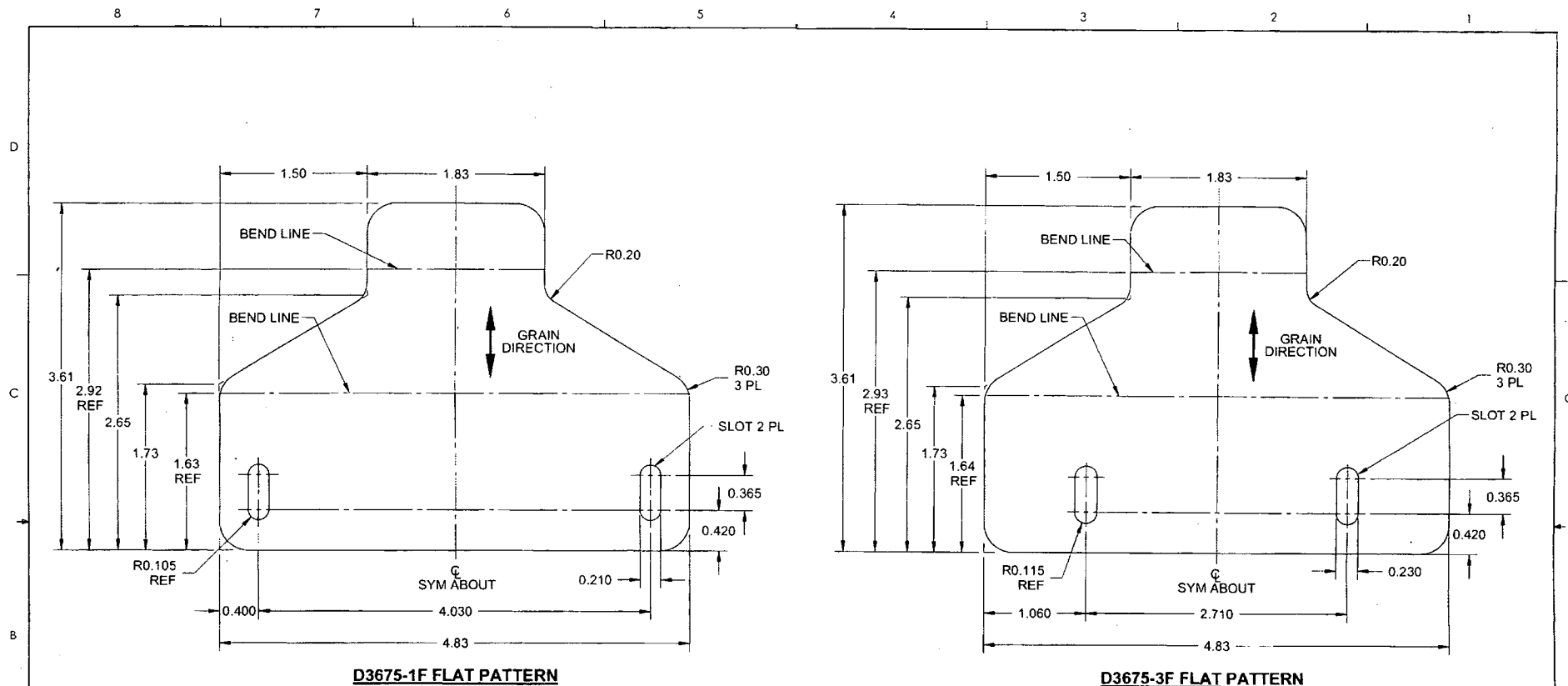
RELEASED
2011-03-31

- NOTES:
- 1) MATERIAL: SEE SHEET 6
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.31 lbs EACH
 - 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>ALS</i>		
CHECKED	<i>ALS</i>	DRAWING NO. D3675	REV. D SHEET 4 OF 6
MFG. APPR.	<i>ALS</i>	TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR) SCALE NTS	
APPROVED	<i>ALS</i>		
DE APPR.	<i>ALS</i>	DATE 11.03.21	
DATE	11.03.21		

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8 7 6 5 4 3 2 1



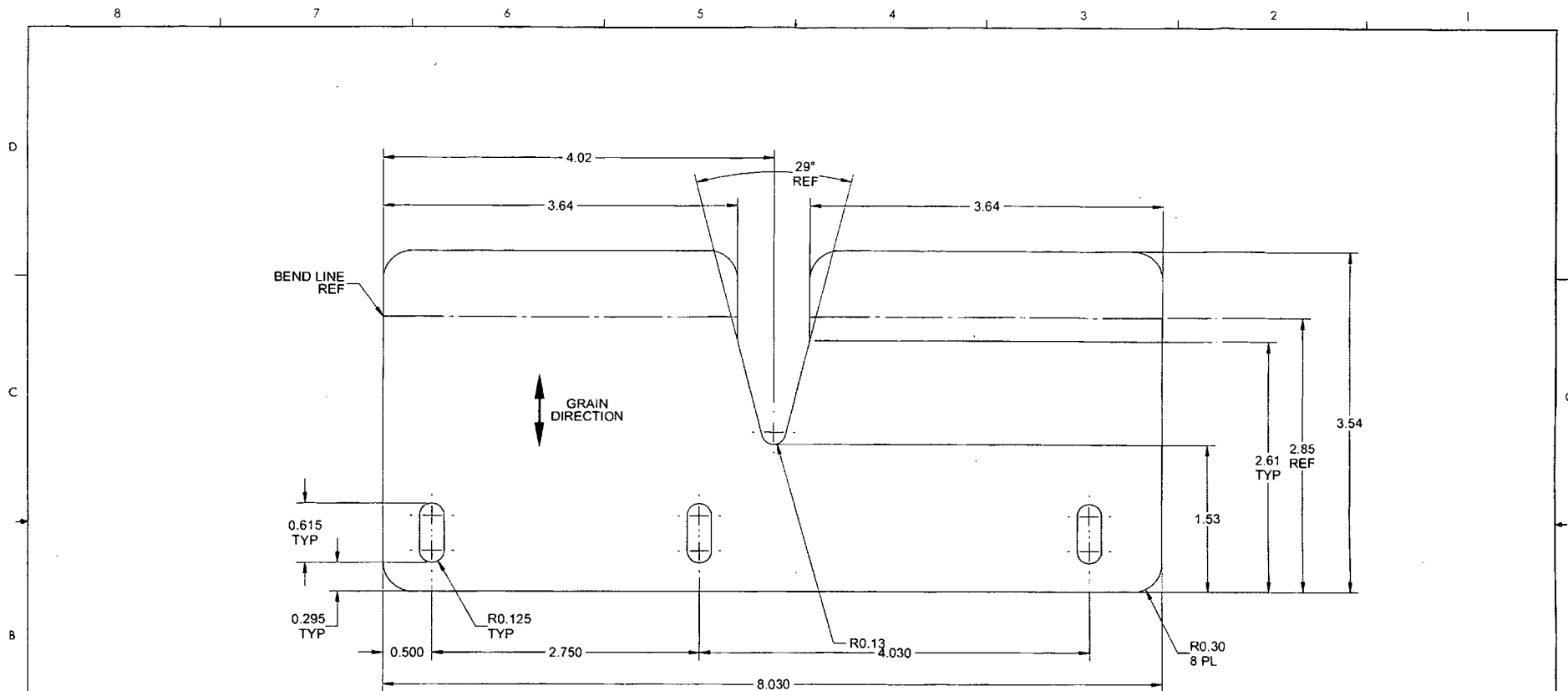
RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3675	SHEET 5 OF 6
APPROVED	<i>AS</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.	<i>AS</i>	(COMPOSITE DOOR)	SCALE
DATE	11.03.21	NTS	

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D3675-5F FLAT PATTERN

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3675	SHEET 6 OF 6
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	SLIDING DOOR BRACKET	NTS
DATE	11.03.21	(COMPOSITE DOOR)	

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